

Work Order ID 63237

Tuesday, October 26, 2010 8:33:09 AM

Page 1

Item ID: D3536-37

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 10/26/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 10-10-26

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3536

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: 1 ☐ 2-
Deburr if necessary

10-11-2

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-11-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/103

(12)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63237

Tuesday, October 26, 2010 8:33:09 AM



Page 2

Item ID:	D3536-37	Accept		Setup	Start	
Revision ID:						
Item Name:	Gasket				Stop	
Start Date:	10/26/2010	Start Qty:	12.00			
Required Date:	10/29/2010	Req'd Qty:	12.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>FP</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/11/32 122

10/11/04
MF
10-11-4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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* NOTE: Date & initial all entries

Picklist Print

Tuesday, October 26, 2010 8:33:09 AM

Page 1

Work Order ID: 63237

Parent Item: D3536-37

Parent Item Name: Gasket



Start Date: 10/26/2010

Required Date: 10/29/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	538.4220	0.7534	10.04533			
NEOPRENE SHEET 0.063												10-11-2	

Location

Loc Qty

Loc Code

MAT

538.422

115500

138.422

115916

400

115500

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 63237
Description: Gasket		Part Number: D3536-37
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	X		V IB 02	
0.30	+/-0.030	.301	X		V	
0.30	+/-0.030	.303	X		V	
1.89	+/-0.030	1.892	X		V	
6.00	+/-0.030	6.00	X		T H301	
8.00	+/-0.030	8.00	X		T	
16.00	+/-0.030	16.00	X		T	
21.00	+/-0.030	21.00	X		T	
2.00	+/-0.030	1.998	X		V	
4.75	+/-0.030	4.75	X		T	
9.50	+/-0.030	9.50	X		T	
14.25	+/-0.030	14.25	X		T	
17.75	+/-0.030	17.75	X		T	
22.50	+/-0.030	22.50	X		T	
27.25	+/-0.030	27.25	X		T	
30.75	+/-0.030	30.75	X		T	
0.063	+/-0.010	.061	X		V	

Measured by: RB
Date: 10-11-2

Audited by: S
Date: 10/11/03

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	AA

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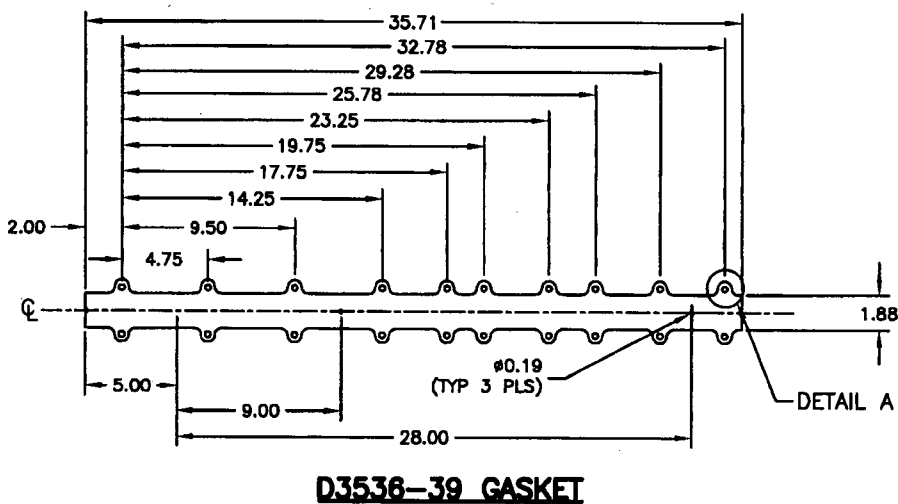
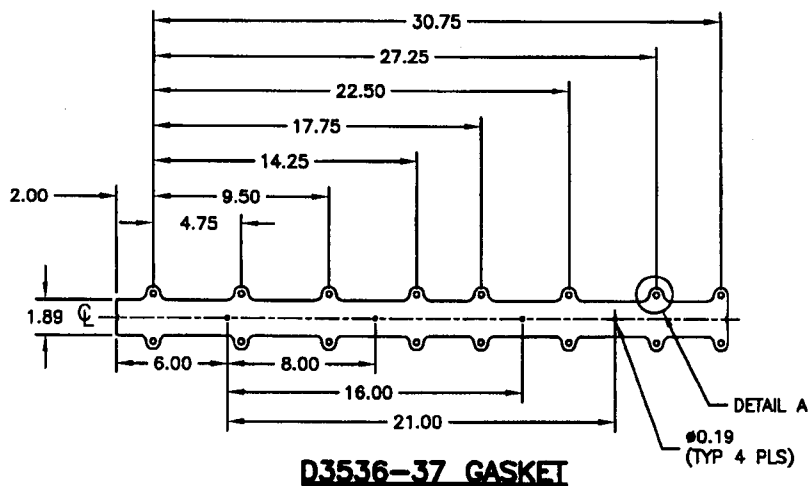
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
				SCALE 1:10



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

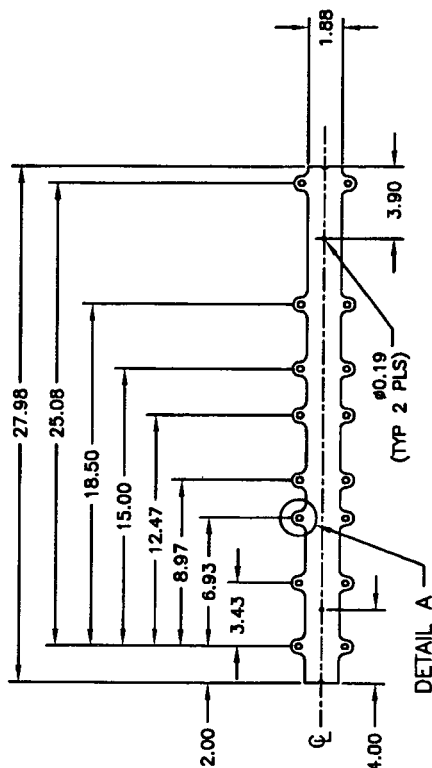
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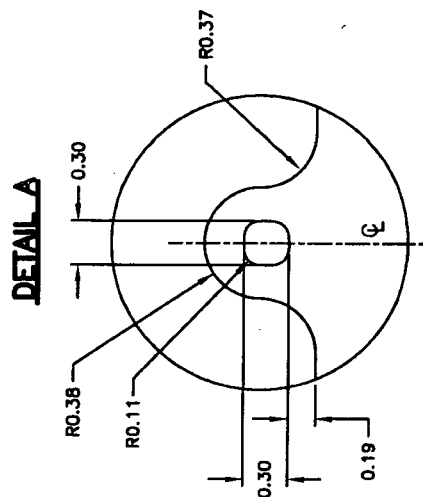


DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED <i>[Signature]</i>	DRAWING NO. D3536	REV. A SHEET 6 OF 6
DATE 06.10.25		TITLE GASKET	SCALE 1:10

RELEASED
07.02.12 *[Signature]*



D3536-41 GASKET



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

#63366
1

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